

Work Order ID 131165

131165

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March-27-15 9:06:38 AM

Item ID: D3506-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 27/03/2015 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 30/03/2015 Req'd Qty: 30.00 ***30*** Customer:

Reference: *[Signature]* 15-03-27

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3506	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3506								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(30) _____ *02/15/03/27*

(30) _____ *02/15/03/27*

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Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA640 and Dwg D3506

QC2- Inspect parts off machine FAI/FAIB

Memo

Memo

Quality Control

QC8- Inspect parts - second check

Memo

Memo

Quality Control

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
150		0.00								
150	Small Fab					30x			15/03/30	DAS 36 9-89
Small Fab	Memo	0.00								
Small Fab	C'sink as per Dwg D3506 (On Flat side)									
160		0.00								
160	QC5- Inspect part completeness to step on W/O	0.00								DAS 38 9-89
QC	Memo	0.00								
Quality Control										
170		0.00								
170	Chemical Conversion Coat per QSI005 4.1	0.00								
HandFinish	Memo	0.00								
Hand Finishing										

MAR 30 2015

30 0 15-3-30

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
180						(30)			
QC	Memo	0.00							
Quality Control									MAR 31 2015
190	Identify as per dwg & Stock Location: LG001	0.00							
190						30X			DAS 28 9-89
Packaging	Memo	0.00							MAR 31 2015
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									MLJ 15-03-31

15-3-31

Picklist Print

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Parent Item: D3506-3

D3506-3

Parent Item Name: Doubler

Start Date: 27/03/2015

Required Date: 30/03/2015

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 06-05-31 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.100

Purchased

No

120

sf

90.8000

0.0078

1

M6061T6S 100

De 15/03/27

6061-T6 .100 Sheet

Location

Loc Qty

Loc Code

MAT020

90.8

m128315

14

m129165

30.5

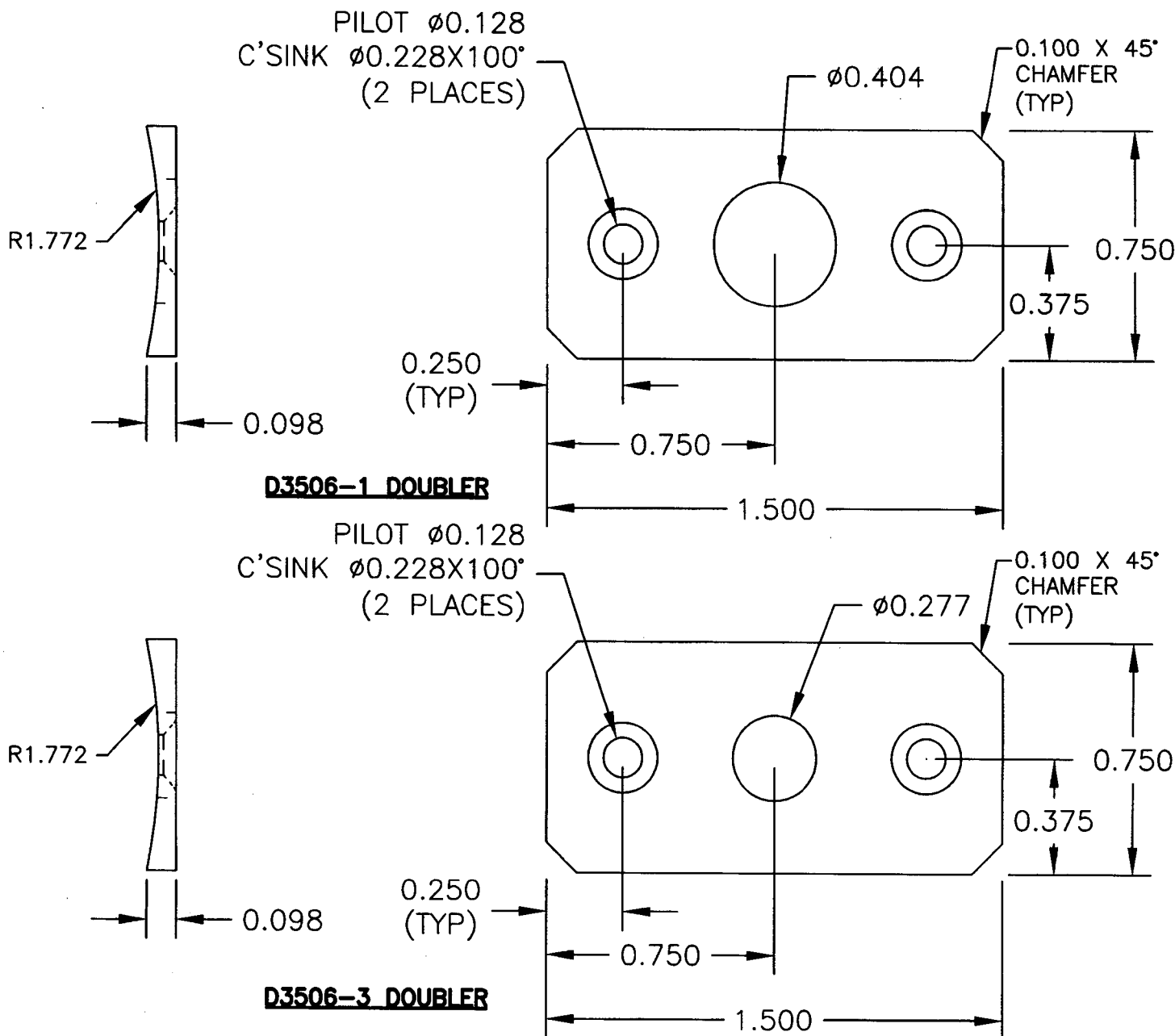
m131352

46.3

.8

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.02 PH
per EWN #361

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DART AEROSPACE LTD		Work Order:	121165
Description: Doubler		Part Number:	D3506-3
Inspection Dwg: D3506 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø .128	/		6" Vern	OK 05
Ø0.277	+0.006/-0.001	.276	/			
0.750	+/-0.010	.748	/			
1.500	+/-0.010	1.500	/			
0.375	+/-0.010	.374	/			
0.750	+/-0.010	.747	/			
0.250	+/-0.010	.249	/			
0.098	+/-0.010	.100	/			
21.772	± .010	1.772	✓			

Measured by:	DC PK	Audited by:	DAS 44	Prototype Approval:	N/A
Date:	15/03/27	Date:	15/03/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.02	New Issue	KJ/JLM	